



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5122-1TRN
Job Sheet 189176



Part No: D5122-1TRN

Job Qty: 8 pcs

Part Name: Center Support, Upper, Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/20/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV. A NEW ISSUE JFS 14/07/09 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	8 pcs	2/20/19	2/20/19	0.25	14.55	Doosan - 1		J.C.L.
110	QC 2	8 pcs	2/20/19	2/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L.
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S148260



Part: D5122-1TRN

Job No: 189176

Serial No/Batch: S148260

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/26/19

120	QC 8	8 pcs	2/20/19	0.00	0.00	QC 2 - 8	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
							Kt - 2019-02-11
130	Packaging 3-1 - Stock - B4B	8 pcs	2/20/19	0.00	0.00	Packaging 3 - 1 - B4B	Kt - 2019-02-11
						Packaging 3 - 2 - B4B	Kt - 2019-02-11
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - SA	8 pcs	2/20/19	0.00	0.00	QC 21 - SA - 21	

Part Op 100 - Doosan Lathe) Turn blank as per Folio FB325
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)LOCATION: MAT060
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

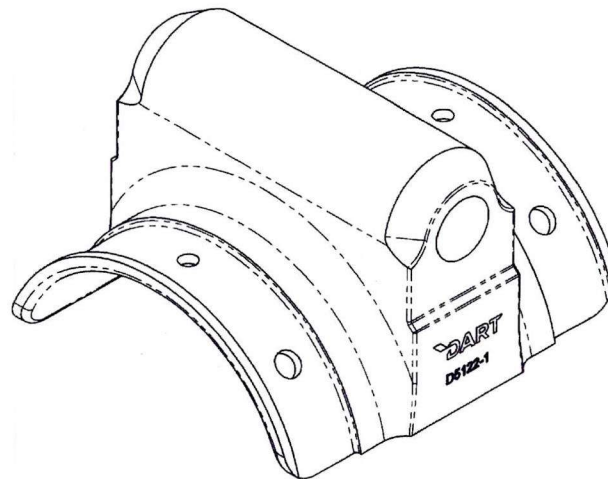
Part / Item	Component Name	Quantity	Operation	Container
D6104-011	17-4 SS Roundbar 6.50"OD	8 pcs (1 ea)	100-Doosan - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-011	8	5	0

Part Specifications

Specifications could not be found.



D5122-1 CENTER SUPPORT

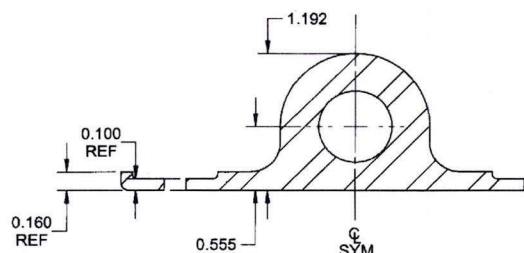
NOTES:

- 1) MATERIAL: MAKE FROM D5122-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5122-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 2.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5122-1-REVA.SLDPRT"

A		NEW ISSUE		AP	14.06.02
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AP				
CHECKED	CP	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5122	SHEET 1 OF 3		
APPROVED	MP	TITLE	SCALE		
DE APPR.	DS	CENTER SUPPORT	NTS		
DATE		14.06.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

APPROVED

RELEASED
2014-08-25
MP



SECTION A-A

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

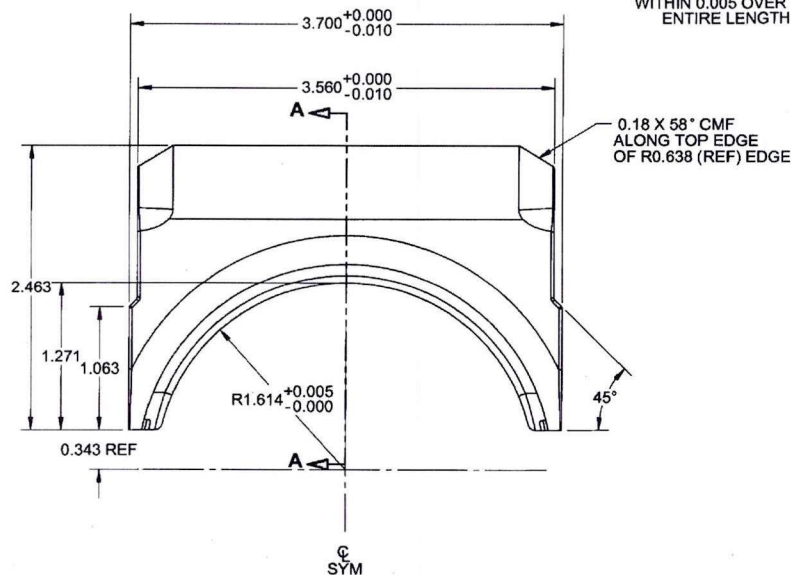
R0.063
AROUND INSIDE EDGE

0.464 REF

OPTIONAL $\phi 0.261$ REF
TOOLING HOLE,
LOCATED AT 45° TO VERTICAL
4 PL

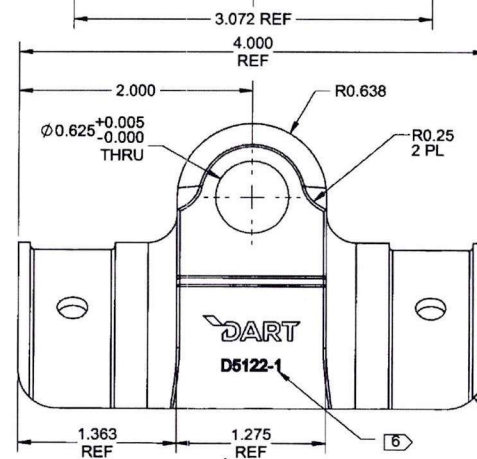
OPTIONAL $\phi 0.189$ REF
TOOLING HOLE,
2 PL

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH



D5122-1 CENTER SUPPORT

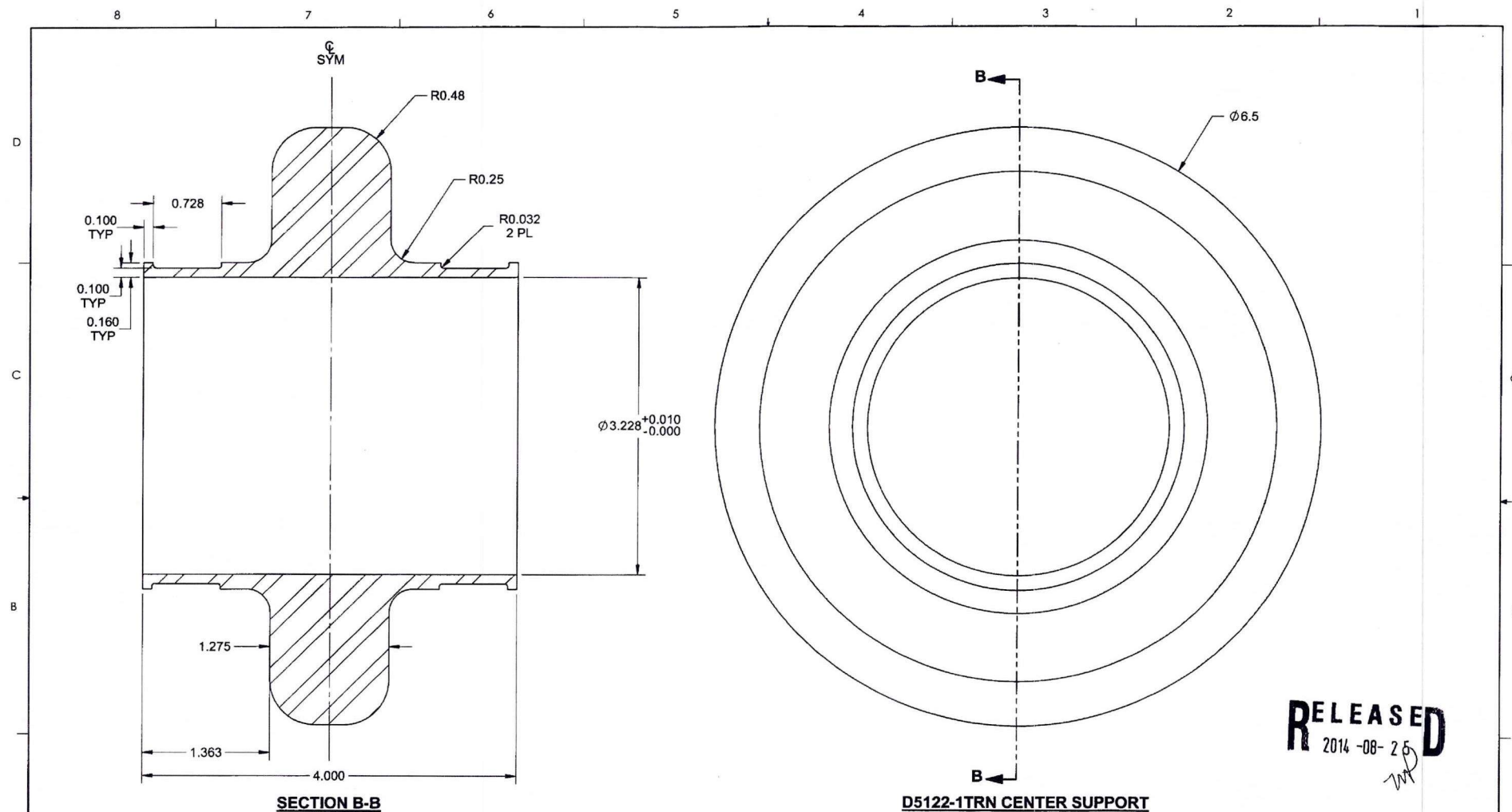
0.18 X 58° CMF
ALONG TOP EDGE
OF R0.638 (REF) EDGE



RELEASED
2014-08-25

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5122	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CENTER SUPPORT	NTS
DATE	14.06.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2014-08-25

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 11.25 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5122	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CENTER SUPPORT	NTS
DATE	14.06.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	189136
Description: Center Support		Part Number:	D5122-1TRN
Inspection Dwg: D5122	Rev: A		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:		Checked by:		QC Inspector:	
Date:	19/01/20	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	